

# Work Order ID 85751

June-14-12 1:58:47 PM

**\*85751\***

Page 1

Item ID: D4149-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Crosstube Lug Plate, Aft

Start Date: 14/06/2012 Start Qty: 40.00

**\*40\***

Cust Item ID:

Required Date: 28/06/2012 Req'd Qty: 40.00

**\*40\***

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/14

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4149

C

100

0.00

**\*100\***

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D4149

Prog Rev: E

Dwg Rev: E

Deburr as required

RB12-6-16

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

RB12-6-16

# Work Order ID 85751

June-14-12 1:58:47 PM

**\*85751\***

Page 2

Item ID: D4149-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Crosstube Lug Plate, Aft

Start Date: 14/06/2012 Start Qty: 40.00

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Cust Item ID:

Required Date: 28/06/2012 Req'd Qty: 40.00

**\*40\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: 102

0.00

**\*150\***

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

400 12/6/19  
12/6/19  
1206-19

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>																
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unauthorized <input type="checkbox"/>									

### FAULT CATEGORY

Landing Gear	Hardware	General
<input type="checkbox"/> Bending Passes Below Min	<input type="checkbox"/> Breaking	<input type="checkbox"/> Burrs
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> Missing	<input type="checkbox"/> Contamination
<input type="checkbox"/> Cracks	<input type="checkbox"/> Size/Length	<input type="checkbox"/> Cut Too Short
<input type="checkbox"/> Crushed/Crimp at Bending	<input type="checkbox"/> Spinning	<input type="checkbox"/> Documentation/Data
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Threading	<input type="checkbox"/> Finish
<input type="checkbox"/> Other	<input type="checkbox"/> Wrong	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Positioned Wrong		<input type="checkbox"/> Inspection Unqualified
<input type="checkbox"/> Ripples on Inner Bend	<b>Drill Holes</b>	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Misaligned	<input type="checkbox"/> Jigs/Fixtures/Tooling
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Kit Incorrect
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Over/Undersized	<input type="checkbox"/> Kit Missing
	<input type="checkbox"/> Too Many	<input type="checkbox"/> Maintenance
		<input type="checkbox"/> Mislabeled
		<input type="checkbox"/> Off-Set
		<input type="checkbox"/> Orientation Misread
		<input type="checkbox"/> Out of Calibration
		<input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Lost
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Raw Material
		<input type="checkbox"/> Set-up
		<input type="checkbox"/> Supplier
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

# Picklist Print

June-14-12 1:58:50 PM

Page 1

Work Order ID: 85751

**\*85751\***

Parent Item: D4149-1

**\*D4149-1\***

Parent Item Name: Crosstube Lug Plate, Aft

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 40.00

Required Qty: 40.00

## Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 11.03.03 as per revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	102.3760	0.1355	5.705263			

**\*M304S11GA\***

304/316 0.125 Sheet

**\*\***

812-6-16

## Location

## Loc Qty

## Loc Code

MAT020

102.376

121380

24.9

121780

77.476

121780

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
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Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unauthorized <input type="checkbox"/>									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>Hardware</b> <input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong  <b>Drill Holes</b> <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many	<b>General</b> <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing  <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material
---	--	---

<input type="checkbox"/> Set-up
<input type="checkbox"/> Supplier
<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Weld
<input type="checkbox"/> Wrong Stock Pulled
<input type="checkbox"/> Other

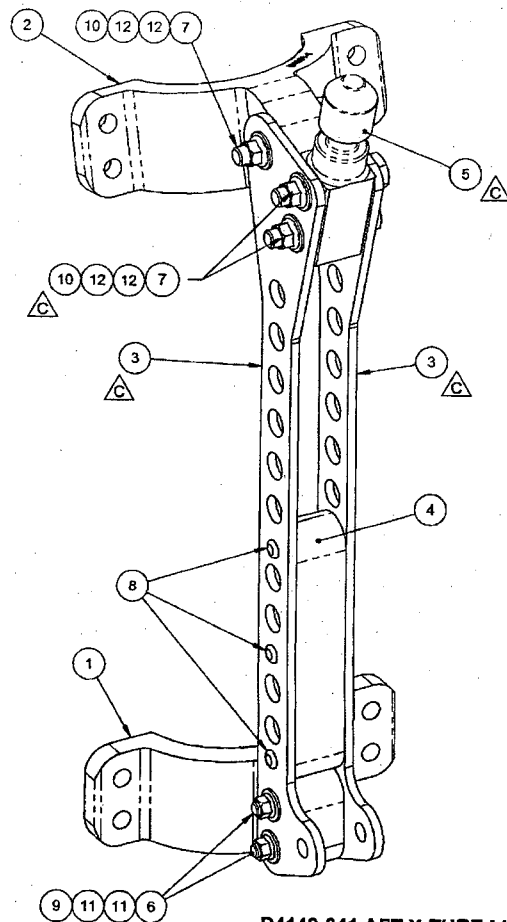
<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	85751
<b>Description:</b> Aft Crosstube Lug Plate		<b>Part Number:</b>	D4149-1
<b>Inspection Dwg:</b> D4149 <b>Rev:</b> C		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.131	K		V BoZ	
Ø0.191	+0.005/-0.001	.193	K		V	
Ø0.257	+0.006/-0.001	.258	8		V	
Ø0.38	+0.006/-0.001	.379	L		V	
0.380	+/-0.010	.381	2		V	
0.469	+/-0.010	.464	2		V	
0.310	+/-0.010	.311	2		V	
0.750	+/-0.010	.750	L		V	
3.25	+/-0.030	3.253	2		V	
0.65	+/-0.030	.653	8		V	
0.63	+/-0.030	.629	L		V	
5.46	+/-0.030	5.463	2		V	
3.80	+/-0.030	3.803	2		V	
2.13	+/-0.030	2.132	L		V	
1.313	+/-0.010	1.310	2		V	
0.625	+/-0.010	.628	2		V	
0.375	+/-0.010	.378	L		V	
1.175	+/-0.010	1.174	2		V	
0.752	+/-0.010	.751	L		V	
1.588	+/-0.010	1.588	2		V	
1.587	+/-0.010	1.586	L		V	
11.15	+/-0.030	11.152	2		PR @ W 307	
0.750	+/-0.010	.759	2		V	
1.55	+/-0.030	1.553	2		V	
1.12	+/-0.030	1.12	L		V	
8.42	+/-0.030	8.42	2		P	
2.70	+/-0.030	2.70	L		V	
0.125	+/-0.010	.118	2		V	
Ø0.252	+0.003/-0.000	.252	2		V	

<b>Measured by:</b>	B	<b>Audited by:</b>	S	<b>Preliminary Approval:</b>	
<b>Date:</b>	12-6-16	<b>Date:</b>	12/6/16	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	12.02.01	Dimensions updated per Dwg Rev C	KJ	



**D4149-041 AFT X-TUBE LUG ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.21 lbs

ITEM	QTY	P/N	DESCRIPTION
	X	D4149-041	AFT X-TUBE LUG ASSY
1	1	D3910-1	X-TUBE LUG
2	1	D4091-1	MOUNTING LUG
3	2	D4149-1	AFT X-TUBE LUG PLATE
4	1	D4149-3	SPACER
5	1	D4149-5	EYEBOLT STUD
6	2	AN3C12A	BOLT
7	3	AN4C13A	BOLT
8	3	MS20615-4M18	RIVET
9	2	MS21043C3	NUT
10	3	MS21043C4	NUT
11	4	NAS1149C0332R	WASHER
12	6	NAS1149C0432R	WASHER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 85751 MLJ  
12/06/14

RELEASED  
2011-02-26

C	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.250" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, D7-2)	SC	11.02.22
B	MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); ADDED D4149-5 (SHT 5); D4149-5 WAS D3909-5 (ZN D3-1 & D7-2); REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, C7-1, B7-2 & B3-2); Ø.0191 2 PL REPLACES Ø.0129 3 PL (ZN D8-3); REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
DATE	11.02.22	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUBJECT TO THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

AN4C13A BOLT  
NAS1149C0432R WASHER, 2X  
MS21043C4 NUT  
3PL

D4149-5  
EYEBOLT STUD

MS20615-4M18  
RIVET  
3 PL

**D4149-041 AFT X-TUBE LUG ASSY**

D4091-1  
MOUNTING LUG

D4149-1  
AFT X-TUBE LUG PLATE  
2 PL

D4149-3  
SPACER

AN3C12A BOLT  
NAS1149C0332R WASHER, 2X  
MS21043C3 NUT  
2 PL

D3910-1  
X-TUBE LUG

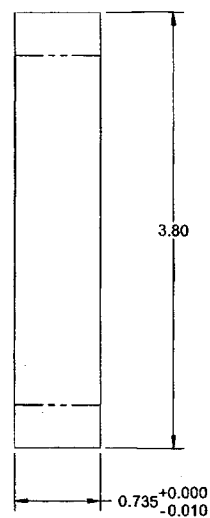
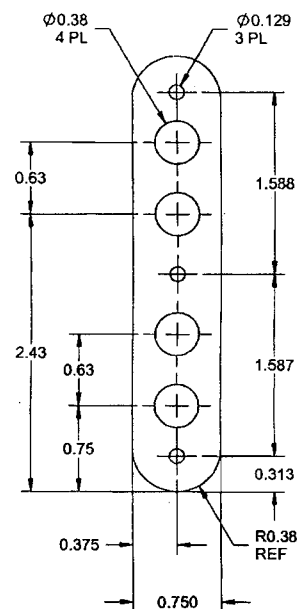
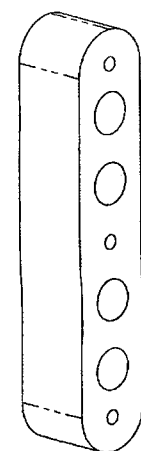
**RELEASED**  
2011-02-24  
MP

DESIGN	MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO. <b>D4149</b>	REV. C SHEET 2 OF 5
MFG. APPR.		TITLE <b>AFT X-TUBE LUG ASSY</b>	SCALE NTS
APPROVED		<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DE APPR.			
DATE	11.02.22		





25751



**D4149-3 SPACER**

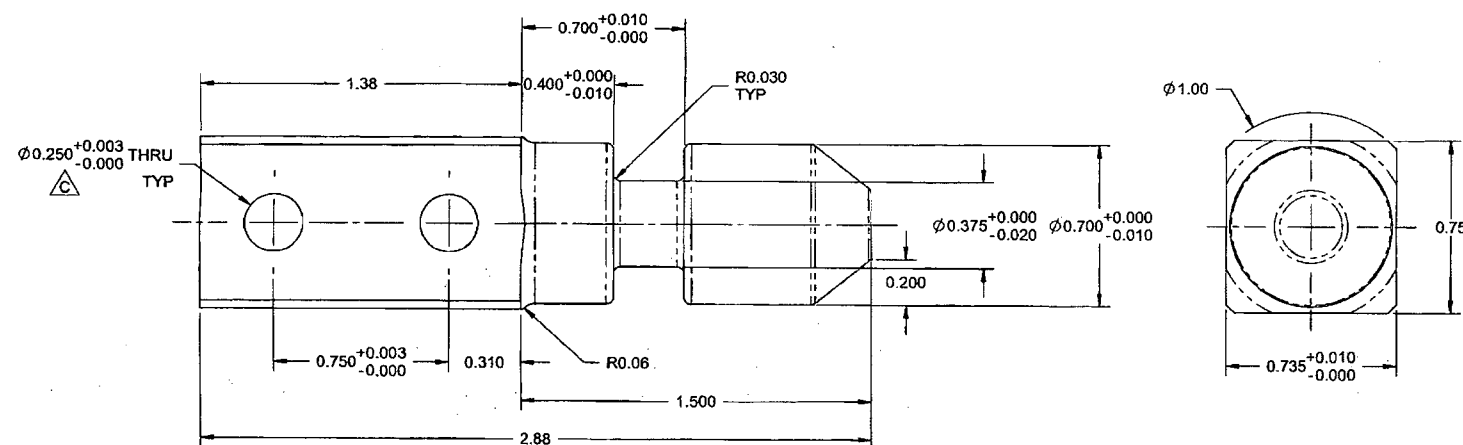
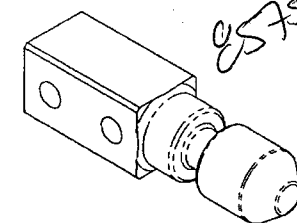
RELEASED  
2011-02-25

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582  
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.47 lbs

DESIGN	MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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Q5751



**D4149-5 EYEBOLT STUD**

RELEASED  
2011-02-24

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582  
REF DART SPEC MS304B OR MS303B
  - 2) FINISH: NONE
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-5" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.32 lbs

DESIGN	MB	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D4149</b>	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>AFT X-TUBE LUG ASSY</b>	NTS
DATE	11.02.22	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	